

Work Order ID 75042

75042


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October-17-11 10:31:55 AM

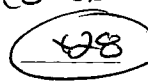

Item ID: D3794-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket
 Start Date: 17/10/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 27/10/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/11 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3794	Rev A								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3794 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary
B11-10-18


110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control
B11-10-18

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control
8/10/12
comb
 
 Ph →

W/O: 75042		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3794-1 PAR #: NA Fault Category: Small PAD / water Jet NCR: Yes No DQA: NA Date: 11.10.25
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: NA Date: 11/10/25

NCR: 11-926		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/19	#110	Qty x1 Found with large cut in middle of part. R.C. started Roll and Damage.	AS7042 11/10/19	Scrap + Destroy no Re-Work extra made	11-10-19	AS7042 11/10/19	AS7042 11/10/19	AS7042 11/10/19
		Process						

NOTE: Date & initial all entries

Work Order ID 75042***75042***

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October-17-11 10:31:55 AM

Item ID: D3794-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Gasket

Stop ***NS2***

Start Date: 17/10/2011 Start Qty: 12.00

12

Cust Item ID:

Required Date: 27/10/2011 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: FA

0.00

130

Packaging

Memo

0.00

Packaging

11/10/19 SL 282

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

11/10/20 MFMF
11-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-17-11 10:32:00 AM

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Work Order ID: 75042

75042

Parent Item: D3794-1

D3794-1

Parent Item Name: Gasket

Start Date: 17/10/2011

Required Date: 27/10/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MNEO60S.063

Purchased

No

100

sf

473.8500

0.5902

7.869333

17.

MNEO60S 063

Bk-10-18

NEOPRENE SHEET 0.063

Location

Loc Qty

Loc Code

MAT052

473.85

117295

55.68

118026

127.87

118663

4.3

119130

286

119130



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	75042
Description: Gasket		Part Number:	D3794-1
Inspection Dwg: D3794 Rev: A		Page 1 of 1	

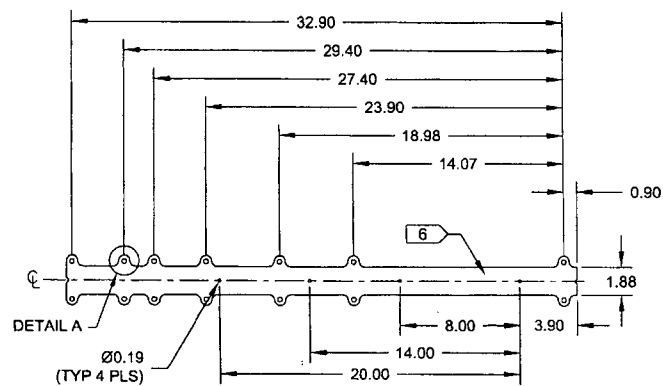
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

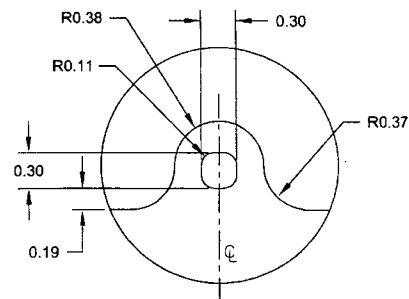
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.190	✓		V B02	
0.300 x 0.300	+/-0.010	3.4 x 3.6	✓		V	
1.88	+/-0.030	1.883	✓		V	
0.90	+/-0.030	.908	✓		V	
3.90	+/-0.030	3.90	✓		T B01	
8.00	+/-0.030	8.00	✓		T	
14.00	+/-0.030	14.00	✓		T	
20.00	+/-0.030	20.00	✓		T	
14.07	+/-0.030	14.07	✓		T	
18.98	+/-0.030	18.98	✓		T	
23.90	+/-0.030	23.90	✓		T	
27.40	+/-0.030	27.40	✓		T	
29.40	+/-0.030	29.40	✓		T	
32.90	+/-0.030	32.90	✓		T	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-10-18	Date:	11/10/19	Date:	N/A

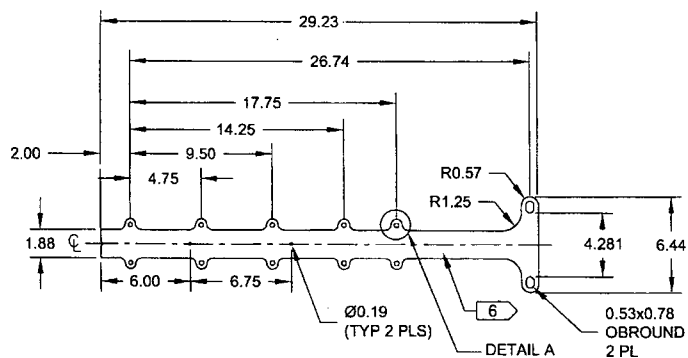
Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	DA



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75042

11-10-17

RELEASED
08-05-15/17

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14		

DART AEROSPACE USA, INC
PORT HADLOCK, WA
DRAWING NO. D3794
REV. A
SHEET 1 OF 1
TITLE GASKET
SCALE NTS
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